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(71) Applicant: **Mumoli, José Alejandro**
1684 C.J. El Palomar, Buenos Aires (AR)

(72) Inventor: **Mumoli, José Alejandro**
1684 C.J. El Palomar, Buenos Aires (AR)

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(74) Representative: **Manresa Val, Manuel et al**
Rambla de Catalunya, 32,2o 2a
08007 Barcelona (ES)

(54) **A single-dose soap unit and method of manufacturing**

(57) The invention provides a single-dose soap for use only once, as a disposable soap unit (1), the soap unit (1) having a high solubility in order to be quickly dissolved during a washing operation, the soap unit comprising lauryl sodium sulfate, a first hydrophilic disinte-

grating agent, an agglutinating agent, and a second hydrophilic disintegrating agent for causing a sudden disintegration and dissolution of the soap when contacting with a liquid for the washing operation. The invention also provides a method for manufacturing the soap unit (1).

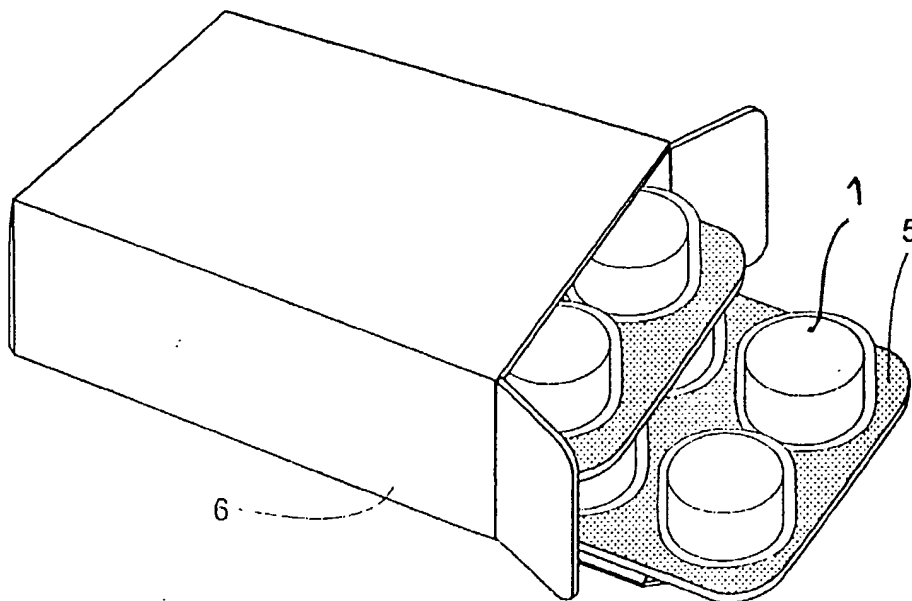


Fig. 6

EP 1 108 777 A2

Description

BACKGROUND OF THE INVENTION

5 1. Field of the Invention.

[0001] The present invention relates to cleaning elements and, more particularly refers to a soap mixture for use in personal cleaning, such as a toilet soap, and even more preferably the invention relates to a soap unit to be used only once, that is as a disposable unit in a format and dose enough for use as soap bar, shampoo, hair conditioner and any

10 other cleaning and cleansing element for personal, domestic or industrial application.
[0002] The invention also refers to a method of manufacturing said single-dose solid soap unit.

2. Description of the Prior Art.

15 [0003] For several number of years several formats and shapes have been used for various kinds of soaps used for personal applications and other uses in the domestic and industrial areas. The formats and presentation of these products have always been the results of studies related to the particular use of the soap, that is in liquid, powder and solid formulations.

20 [0004] According to the practice, a soap is a past resulting from the combination of an alkali with oil acids and other fatty components. In the pharmaceutical field, a soap is a combination of ammonium or another alkali or a metal oxide of oils, fatty components and resins. In soft soaps the alkali is the potash and in hard soaps the alkali is the soda ash. Some typical formulae for soaps used for hygiene are as follows:

25	Washing Soap (White):	
	White Tallow (100%)	97.00 wt%;
	Optic White Agent	0.02 wt%;
	Edta Disodium	2.00 wt%;
	Perfume Essence	excp;
30	Ettoxilated Fatty Alcohol (Lauryl) (nonionic surfactant);	
	Sodium Alkylsulfanate (anionic surfactant);	
	Sodium soap;	
35	Water softening;	
	Biologic catalyst;	
	Glazing Agent;	
40	Perfumes.	

Hair Conditioner:
Demineralized Water;
Cetrimonium Chloride;
45 Zetil-Alcohol;
Essence;
Metyl Chloroisotiazolinone;
Metyl Isotyazolinone; and
50 Citric Acid.

55	Toilet Soap:	
	Modified Coconut Detanolamide	0.50 wt%;
	Anhydrous Lanoline	1.00 wt%;
	Disodium Edta	0.03 wt%;
	Perfume	1.20 wt%;

(continued)

Toilet Soap:	
Whitened Soap Pellets(bovine tallow) Coconut Tallow.	97.27 wt%;

Shampoo:	
Demineralized Water	62.47 wt%;
Glycerin	0.70 wt%;
Sodium Etoxi Sulfate Lauryl (25%)	28.00 wt%;
Flamatenso (Cocoamide Propil Beteme)	3.00 wt%;
Modified Coconut Dietanolamide	3.00 wt%;
Disodium Edta	0.10 wt%;
Citric Acid	2.00 wt%;
Bright Red 4R	0.01 wt%;
Bactekill 2001 (50%)	0.3 wt%;
Sandalwood Alcoholic Extract	0.05 wt%;
Other Perfumes exc.	0.35 wt%.

[0005] While the above formulae have been in use during a considerable number of years, some formats and presentations have been modified according to the modern market demands. In the particular case of the toilet soap bars, the same have been commercialized in larger or smaller pieces of soap, but always such units had a size enough to use the soap bar for several times. While all these soap bars have been designed for personal use, these bars are exposed to the use by many different persons either in the house, or in worse conditions, in public locations, such as toilets or bathrooms at restaurants, gas stations, etc. It is quite common to find a soap bar of this type with many impurities like dirty, down, hair and other undesired elements. While the bar is found in solid state, dry and with consistency enough to be used, the people is reluctant to use the soap bar in the above dirty conditions and, generally, the soap bar is disposed even with an almost entire original size, that is with a little use. In other words, the soap is wasted prematurely because of its appearance.

[0006] Other cleansing products such as the shampoos and hair conditioners are commercialized in large and non practical containers which, in addition to the inconveniences of these containers in their use, the same are spoilage and dangerous agents for the environment when empty. Some times, the cost of the container reaches the cost of the contained product and, even if special caps are fitted in the container few possibilities of metering the content are provided for the consumer. Generally, when used by children or in baths at sport clubs, hotels and other public places, the product is remarkably wasted such as poured onto the floor, used unnecessarily in excess, etc.

[0007] In view of the above drawbacks, it would be therefore convenient to have a kind of soap, shampoo, hair conditioner or any other cleansing product, preferably a personal toilet product, capable of providing a personal unit with a small size, to be used once and disposed without waste of the product. Even if a person skilled in the art would think the question is easily resolved by making a soap bar or cleansing product as small as possible to only cover the needs of an individual during a hands washing operation or a shower, this attempt has been shown not a solution to this problem as long as too much time must be awaited for until such presumable soap bar is dissolved in the hands, over the human body or in any other application.

[0008] It would therefore be desirable to find such a small soap unit capable of being applied, preferably, in personal hygiene and having a high capacity to be quickly dissolved in a washing or cleansing operation.

3. Summary of the Invention.

[0009] It is therefore an object of the present invention to provide a single-dose soap for use only once, as a disposable soap unit, the soap unit having a high solubility in order to be quickly dissolved during a washing operation, the soap unit comprising lauryl sodium sulfate, a first hydrophilic disintegrating agent, an agglutinating agent, and a second hydrophilic disintegrating agent for causing a sudden disintegration and dissolution of the soap when contacting with a liquid for the washing operation. The invention also provides a method for manufacturing the soap unit.

[0010] It is also an object of the present invention to provide a single-dose soap for use only once, as a disposable soap unit, the soap unit having a high solubility in order to be quickly dissolved during a washing operation, the soap

unit comprising lauryl sodium sulfate, a surfactant agent, an agglutinating agent, and croscarmellose, an hydrophilic disintegrating agent for causing a sudden disintegration and dissolution of the soap when contacting with a liquid for the washing operation. The invention also provides a method for manufacturing the soap unit.

[0011] It is still another object of the present invention to provide single-dose soap body, the soap body having a high solubility in order to be quickly dissolved in a liquid for washing operation, the soap body comprising about 35 wt% to about 98 wt% lauryl sodium sulfate with a 98% purity, a softener agent, and magnesium estearate.

[0012] It is still another object of the present invention to provide single-dose soap body, the soap body having a high solubility in order to be quickly dissolved in a liquid for washing operation, the soap body comprising about 15 wt% to about 25 wt% lauryl sodium sulfate with a 98% purity, about 8 wt% to about 15 wt% of croscarmellose, and/or corn starch.

[0013] It is a further object of the present invention to provide a method of manufacturing a single-dose solid soap body with increased solubility, the soap body being quickly dissolved in a washing operation, the method comprising:

- a) forming a mixture by mixing the following powder components:

- about 15 wt% to about 25 wt% lauryl sodium sulfate,
- about 15 wt% to about 20 wt% of a first hydrophilic disintegrating agent,
- an agglutinating agent, and
- about 50 wt% to about 60 wt% of a second hydrophilic disintegrating agent, the second disintegrating agent causing a sudden disintegration and dissolution of the body upon subject the body to said washing operation.

[0014] It is even another object of the present invention to provide the above mentioned method, wherein the components are compressed from a powder form and agglutinated into a compact and quick soluble solid soap body, such as a solid bar, a solid tablet, a solid pill, solid pellets, solid lozenges, ovules and capsules.

[0015] The above and other objects, features and advantages of this invention will be better understood when taken in connection with the accompanying drawings and description.

BRIEF DESCRIPTION OF THE DRAWINGS

[0016] The present invention is illustrated by way of example in the following drawings wherein:

FIG. 1 shows a top perspective view of a soap unit according to a first embodiment incorporating the concepts of the invention;

FIG. 2 shows a top perspective view of a soap unit according to a second embodiment incorporating the concepts of the invention;

FIG. 3 shows a top perspective view of a soap unit according to a third embodiment incorporating the concepts of the invention;

FIG. 4 shows a top perspective view of a soap unit according to a fourth embodiment incorporating the concepts of the invention;

FIG. 5 shows a top perspective view of a packaging of the soap unit, according to a first embodiment incorporating the concepts of the invention; and

FIG. 6 shows a top perspective view of another alternative packaging also incorporating the concepts of the invention.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0017] As stated above many different formats and sizes of soaps have been commercialized but none of them have been manufactured to be disposed without waste after a single use, preferably a single personal hygiene use. The soap unit according to the invention is quickly dissolved to allow the consumer to use the soap unit without having to wait for a time until the soap mass is dissolved; on the contrary, the inventive soap is suddenly disintegrated or dispersed upon a minimum washing action in a liquid medium. The inventive soap is based in natural agglutinants, cleaning agents and softeners, instead of using the typical tallows, sodium and coloring agents.

[0018] Natural agglutinants, such as gum arabic provides the inventive soap unit with a higher dilution capacity as compared to typical soap formulation; and the cleaning agents may comprise 98 wt% purity powdered sodium sulfate lauryl (surfactant agent), and the softeners may comprise corn starch with a 4% content of humidity and magnesium stearate for an inventive toilet soap unit. A shampoo formulation according to the invention may comprise 35 wt% powdered sodium sulfate lauryl as a cleaning agent, and softeners like corn starch with a 4% content of humidity and magnesium stearate and glycerin of USP/FA quality. Generally according to the invention, all these components are

in powdered and dry form and agglutinated, compressed, sifted and/or packaged or encapsulated according to the method of the invention.

[0019] As it is illustrated in the accompanying drawings, the soap unit of the invention may comprise a square block as shown in Fig. 1, a cylinder shown in Fig. 2, a an ovule with a wet core and an outer gel, preferably solid, cover or lining, or a varied shape like in Fig. 4. Each unit 1 of the invention may be packaged in unitary blister 2 like the one of Fig. 5, with a semi-rigid support 3 and a peelable cover 4, or in a multiple blister 5, illustrated in Fig. 6, which is provided in a box 6. The units may also be packaged in individual boxes, in dispensers or bulky in boxes.

[0020] According to a generic concept of the invention all the components of the soap unit are in powder form. If it is necessary the powders are sifted to have a uniform granulometry. The components are pre-mixed and mixed before subjecting the same to a compressing step.

[0021] A preferred formulation for the soap unit of the invention comprises about 15 wt% to about 25 wt% lauryl sodium sulfate (surfactant agent), about 15 wt% to about 20 wt% of a first hydrophilic disintegrating agent, an agglutinating agent, and about 50 wt% to about 60 wt% of a second hydrophilic disintegrating agent. The first hydrophilic disintegrating agent comprises about 15 wt% to about 25 wt% croscarmellose and the second hydrophilic disintegrating agent comprises about 50-60 wt% micro-crystalline cellulose. The second disintegrating agent causes a sudden disintegration and dissolution of the body upon contacting the soap body with a liquid medium, for example, water for a washing operation. Preferably, all the components are compressed from a powder form and agglutinated into a compact and quick soluble solid soap body. The above formulation also may comprise about 0.5 to 3.5 wt% of at least one colorant essence and perfume, and about 0.5 wt% to 1.5 wt% of at least one bactericide agent. The essence/colorant may be selected from index No. 19140, index No. 42090 or index No. 14700.

[0022] Even according to a more preferred alternative of the invention, the soap comprises about 20 wt% lauryl sodium sulfate (98%), about 20 wt% croscarmellose as the first hydrophilic disintegrating agent, about 50 to 60 wt% Avicel PH200 (micro-crystalline cellulose) as the second hydrophilic disintegrating agent, about 1 wt% of at least one coloring essence, and about 0.5 wt% of at least one bactericide.

[0023] A single-dose solid soap of the invention comprises about 35 wt% to about 98 wt% lauryl sodium sulfate, a softener agent, and magnesium stearate. When the concepts of the invention are applied to a shampoo or hair conditioner, the soap preferably comprises about 10 to 20 wt% lauryl sodium sulfate with a purity of 98%, a softener agent, magnesium stearate, coconut fatty acids alkylolamide, and glycerin USP-FA quality. The softener agent preferably is corn starch with a 4% humidity content and the bactericide is not necessary.

[0024] The proportions and components may be adjusted to manufacture a soap unit such as a solid bar, a solid tablet, a solid pill, solid pellets, solid lozenges and capsules, as well as any other unit with a desired form, shape and size according to the particular application of the soap. Alternatively, a desired formulation form comprises an ovule having a wet interior and an outer gel cover.

[0025] In the above mentioned formulations, the agglutinating agent preferably comprises gum arabic and the product also may comprise surfactant components, co-surfactant components, adjuvant agents, antistatic agents, fragrances, dyes and opacity agents. More preferably, the product comprises about 0.2 wt% to about 1.5 wt% of a wetting adjuvant agent such as vegetal amides, cold cream, lanoline, silicone and its derivatives.

[0026] Sometimes the formulation needs a lubricating agent such as colloidal silica dioxide for improving the disintegration of the product in the compression process.

[0027] According to another aspect of the invention, a method of manufacturing a single-dose soap unit with increased solubility, is provided. The method comprises:

- a) forming a mixture by mixing the following powder components:

about 15 wt% to about 25 wt% lauryl sodium sulfate,
about 15 wt% to about 20 wt% of a first hydrophilic disintegrating agent,
an agglutinating agent, and
about 50 wt% to about 60 wt% of a second hydrophilic disintegrating agent, the second disintegrating agent causing a sudden disintegration and dissolution of the body upon subject the body to said washing operation.
According to a preferred embodiment of the method, the above mixture is compressed and/or agglutinated and conformed into small solid soap bodies. The compression may be carried out at a pressure of 3-7 Kg/cm² and more preferably at a pressure of 4-6 Kg/cm². Before compression, the mixture may be sifted. According to the set of puncheons used in the compressing machine is also important that the hardness of the small solid soap is obtained between 80 to 90 Newton/square inch.

[0028] In above step a) also wetting agents and over-greasing agents may be added to form pills for use as shampoo or hair conditioner. Alternatively the powdered mixture may be encapsulated into single-dose capsules. In connection with most of the formulations, the inventive soap units may be packaged into individual or multiple blisters as shown

in Figs. 5 and 6.

[0029] One or more bactericides, preferably Triclosan, is used for hygienic protection or for neutralizing the product.

[0030] The single-dose presentation as a pill, pastille, capsule, ovule, "dragee" or tablet in a packaging of the type of a light blister or a skin pack, some times recyclable, is an important advantage of the inventive product as compared to typical products, the package being small, light and not spoiling for the environment. In addition, the packaging according to the invention is easily portable, ideal for use in domestic applications, sport clubs, public and private offices, trips, camping, etc. without generating undesired wastes of the product.

EXAMPLE 1

[0031] The following soap composition has been prepared

Sodium Sulfate Lauryl	80mg.
Croscarmellose	80mg.
Essence/color	4mg.
Crospovidone or Avisel	234mg.
Bactericide	2mg.
Enough Quantity for expc.	

EXAMPLE 2

[0032] The following composition has been prepared:

Lauryl Sodium Sulfate - Surfactant	15-25 wt%.
Micro-crystalline cellulose (Avicel PH200), Disintegrating expc.	50-60 wt%.
Sodium Croscarmellose-disintegrating	4-10 wt%.
Corn Starch - disintegrating	4-10 wt%.
Polyvinyl pyrrolidone, agglutinant/stabilizer	3-10 wt%.
Colloidal Silica Dioxide (talc), Inter-granule lubricant	0,5-5 wt%.
Triclosan/Irgasan - Bactericide	0,5-3 wt%.
Magnesium stearate - Lubricant	0,5-2 wt%.
Essence/perfume/colorant	0,5-3 wt%.

[0033] All the components were compressed in a compressing machine at 3455 joule/cm².

[0034] The hardness was controlled during the manufacture within a rate of 75 a 85 Newton/square inch. Thus, tablets or pills from compressed powdered were obtained for personal hygiene, which were single-dose, with high solubility and disintegration capability (soap pills). In the case of shampoo or hair conditioners it may be necessary to reduce the proportion of lauryl sodium sulfate, to eliminate the bactericide and add silicone derivatives, such as dimethyl poly xilosano, lanoline such as deodorized anhydrous lanoline.

[0035] The essences may be perfumes and colorants.

Colorants	0,5 - 1 wt %.
Perfumes	0,5 - 2 wt%.

[0036] The weight of the soap, shampoo and hair conditioner units according to the invention, were preferably between 100 mg. and 24 grs.

[0037] While preferred embodiments of the present invention have been illustrated and described, it will be obvious to those skilled in the art that various changes and modifications may be made therein without departing from the scope of the invention as defined in the appended claims.

Claims

1. A single-dose soap unit, the soap unit having a high solubility in order to be quickly dissolved in a liquid medium for washing operation, the soap unit comprising the following components:
5
about 15 wt% to about 25 wt% lauryl sodium sulfate,
about 15 wt% to about 20 wt% of a first hydrophilic disintegrating agent,
an agglutinating agent, and
10 about 50 wt% to about 60 wt% of a second hydrophilic disintegrating agent, the second disintegrating agent causing a sudden disintegration and dissolution of the unit upon contacting the soap unit with said liquid medium for the washing operation.
2. The soap unit of claim 1, wherein the components being compressed from a powder form and agglutinated into a compact and quick soluble solid soap body.
15
3. The soap unit of claim 2, further comprising:
about 1 wt% of at least one colorant essence, and
20 about 0.5 wt% of at least one bactericide agent.
4. The soap unit of claim 2, wherein the first hydrophilic disintegrating agent comprises about 15 wt% to about 25 wt% croscarmellose and the second hydrophilic disintegrating agent comprises about 58.5 wt% cross-povidone.
5. The soap unit of claim 2, comprising:
25 about 20 wt% lauryl sodium sulfate with a 98% purity,
about 20 wt% croscarmellose as the first hydrophilic disintegrating agent,
about 58.5 wt% micro-crystalline cellulose as the second hydrophilic disintegrating agent,
30 about 1 wt% of at least one coloring essence, and
about 0.5 wt% to about 3 wt% of at least one bactericide.
6. The soap unit of claim 5, wherein all the components are agglutinated from a powder form.
7. A single-dose soap unit, the soap unit having a high solubility in order to be quickly dissolved in a liquid medium in a washing operation, the soap unit comprising the following components:
35 about 15 wt% to about 25 wt% lauryl sodium sulfate with a 98% purity,
a surfactant agent,
magnesium stearate,
40 micro-crystalline cellulose (avicel PH200),
essence, and
colorant.
8. The soap unit of claim 7, comprising
45 about 25 wt% to about 30 wt% lauryl sodium sulfate with a 98% purity,
said surfactant agent,
said magnesium stearate,
coconut fatty acids alkylolamide, and
50 glycerin USP-FA.
9. The soap unit of claim 7, wherein the softener agent is corn starch in a 4 wt% to 8 wt% with a 4% humidity content.
10. The soap unit of claim 8, wherein the softener agent is corn starch with a 4% humidity content.
55
11. The soap unit of claim 2, comprising a body selected from the group comprising a solid bar, a solid tablet, a solid pill, solid pellets, solid lozenges and capsules, all being for only one personal use.

12. The soap unit of claim 2, wherein the agglutinating agent comprises gum arabic.
13. The soap unit of claim 2, wherein the agglutinating agent comprises poly vinyl pyrrolidone.
- 5 14. The soap unit of claim 2, further comprising surfactant components, co-surfactant components, adjuvant agents, antistatic agents, fragrances, dyes and opacity agents.
- 15 15. The soap unit of claim 2, further comprising about 0.2 wt% to about 1.5 wt% of a wetting adjuvant agent selected from the group comprising vegetal amides, cold cream, lanoline, silicone and its derivatives.
- 10 16. The soap unit of claim 15, wherein the lanoline is deodorized anhydrous lanoline and the silicone is poly xiloxane.
17. The soap unit of claim 1, comprising an ovule with a wet interior and an outer gel cover.
- 15 18. A method of manufacturing a single-dose soap unit with an increased solubility for being quickly dissolved in a washing operation, the method comprising:
 - a) forming a mixture by mixing the following powder components:
 - 20 about 15 wt% to about 25 wt% lauryl sodium sulfate,
 - about 15 wt% to about 20 wt% of a first hydrophilic disintegrating agent,
 - an agglutinating agent, and
 - about 50 wt% to about 60 wt% of a second hydrophilic disintegrating agent, the second disintegrating agent causing a sudden disintegration and dissolution of the unit upon subject the unit to said washing
 - 25 operation.
19. The method of claim 18, further comprising the step b) of compressing the mixture and conforming the same into small solid soap units.
- 30 20. The method of claim 19, further comprising the step of sifting the mixture before the compressing step.
21. The method of claim 19, wherein the compressing step is carried out at a pressure of 3-7 Kg/cm².
22. The method of claim 19, wherein the compressing step is carried out at a pressure of 4-6 Kg/cm².
- 35 23. The method of claim 18, wherein step a) further comprises adding wetting agents and over-greasing agents and forming pills for use as one selected from the group comprising shampoo and hair conditioner.
24. The method of claim 23, wherein the over-greasing agents comprise 1.2 wt% to 5 wt% of colloidal silica dioxide.
- 40 25. The method of claim 18, further comprising the step of encapsulating the mixture into single-dose capsules.
26. The method of claim 18, further comprising the step of forming single-dose units and packaging the same into blisters.
- 45 27. The method of claim 18, further comprising the step of forming single-dose units and packaging the same into individual boxes.
28. The method of claim 18, further comprising the step of forming single-dose units and packaging the same into a dispenser.
- 50 29. The method of claim 18, further comprising the step of forming single-dose units and packaging the same into bulk boxes.

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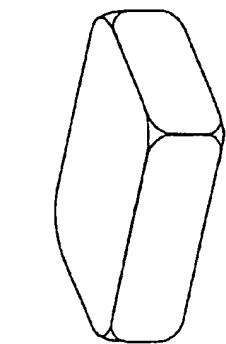


Fig. 1

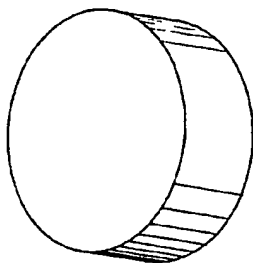


Fig. 2

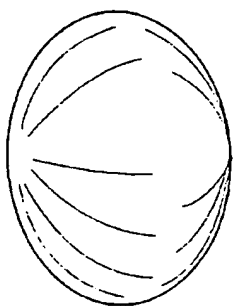


Fig. 3

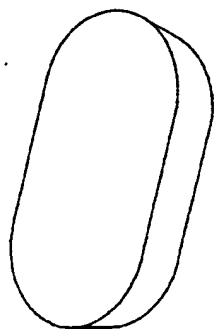


Fig. 4

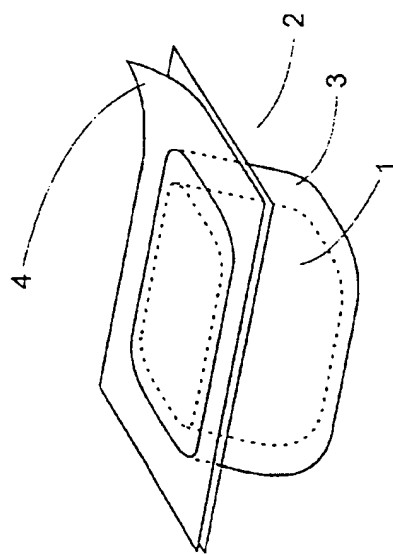


Fig. 5

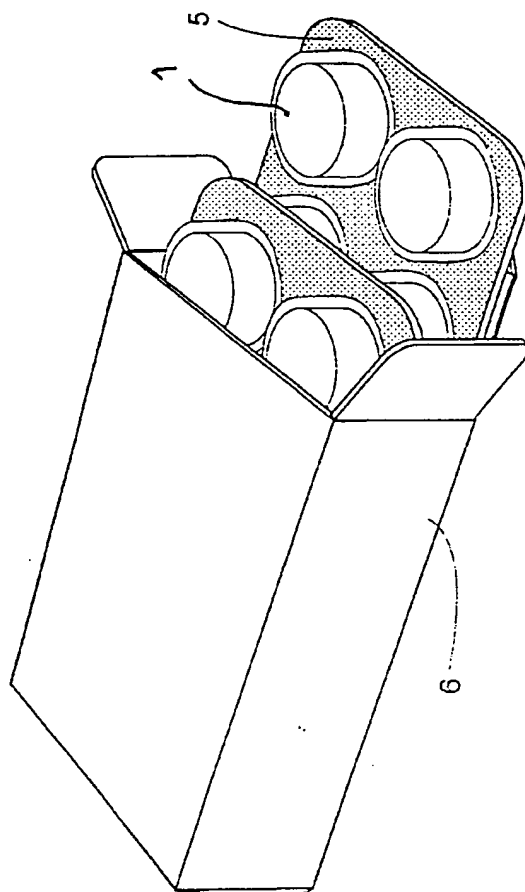


Fig. 6